



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4930-1**Job Sheet 183158****Part No:** D4930-1**Job Qty:** 4 ea**Part Name:** Bearpaw**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 9/13/18**Job Tracking No:****Due Date:** 9/21/18**Created By:** Michelle Gagnon-Donovan**Type:** Stock**Description:****Note:** DWG REV B IPP REV:A NEW ISSUE 13-10-07 JLM VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/21/18	9/21/18	0.00	0.00	Start Up Waterjet		
110	Waterjet	4 pcs	9/21/18	9/21/18	0.00	0.88	Waterjet1		
120	CNC Vertical Machining	4 pcs	9/21/18	9/21/18	0.53	4.82	HAAS1-5		
140	QC	4 pcs	9/21/18	9/21/18	0.00	0.00	QC8		
150	Packaging	4 pcs	9/21/18	9/21/18	0.00	0.00	Packaging3		
160	QC21-SA	4 Ea	9/21/18	9/21/18	0.00	0.00	QC21		

Part Op 110 - CUT BLANK AS PER FILE D4930-1 BLANK

Descriptions: 120 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FB217 and Dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	5.0600 sf (1.265 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	5	922	0



Container No: S110361



Part: D4930-1

Job No: 183158

Serial No/Batch: S110361

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/14/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	12.140Inches ± 0.030	12.170 12.110	12.140	
2	Bearpaw	12.760Inches ± 0.030	12.790 12.730	12.760	
3	Bearpaw	0.380Inches ± 0.030	0.410 0.350	0.380	
4	Bearpaw	1.880Inches ± 0.030	1.910 1.850	1.880	
5	Bearpaw	1.190Inches ± 0.030	1.220 1.160	1.190	
6	Bearpaw	0.260Inches + 0.006 - 0.001	0.266 0.259	0.261	Diameter
7	Bearpaw	0.880Inches + 0.010 - 0.010	0.890 0.870	0.878	Diameter
8	Bearpaw	0.450Inches ± 0.030	0.480 0.420	0.450	
9	Bearpaw	3.850Inches ± 0.010	3.860 3.840	3.850	
10	Bearpaw	5.870Inches ± 0.010	5.880 5.860	5.870	
11	Bearpaw	4.250Inches ± 0.010	4.260 4.240	4.250	
12	Bearpaw	0.070Inches ± 0.030	0.100 0.040	0.07	
13	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	Angle
14	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.265	
15	Bearpaw	0.630Inches ± 0.030	0.660 0.600	0.650	
16	Bearpaw	0.950Inches ± 0.030	0.980 0.920	0.960	
17	Bearpaw	0.130Inches ± 0.030	0.160 0.100	0.130	
18	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	Angle
19	Bearpaw	0.525Inches ± 0.010	0.535 0.515	0.532	
20	Bearpaw	0.375Inches ± 0.010	0.385 0.365	0.385	
21	Bearpaw	1.143Inches ± 0.010	1.153 1.133	1.143	

Plex 9/13/18 9:11 AM Dart.Gagnon.Michelle

$$\begin{array}{r}
 6.38 \times 2 \quad .13 \times 2 \\
 12.760 - 0.260 \\
 \hline
 12.5
 \end{array}$$

